

DART AEROSPACE LTD

Work Order:

18433

Description: Door Assembly

Part Number:

D412-694-01

D412-694-03

Dwg: D412-694 Rev. A page 2, 3, 4, 5, 6; D3140 Rev. B

Qty:

1

Page 1 of 8

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Travelers for: D412-694-01/-03 Door Assembly D3140-5-7 Doubler Kit	<i>[Signature]</i>	03.03.10	1
2	PG	Issue P/O: Description: D3140-05/-07 Door D3119-041/-042 Cover Assembly Supplier: Delastek Ship to Delastek <u>Qty</u> <u>Part Number</u> <u>Description</u> <u>Batch</u> 1 D3140-5-7 Doubler Kit	<i>[Signature]</i>	03.12.18	
3	RG	Receive D3140-05/-07 Door and D3119-041/-042 Cover Assembly. Inspect for transit damage. <b>Ensure a copy of certification of conformity and process sheet from Delastek is attached.</b>			
4	QC3	Visual inspection. Check for void spot and pins. Check over all dimensions and windows as per Dwg D3140.			
5	CA	Drill Pilot hole Ø(#40) using B30-23000-1A as per Dwg D412-694 page 4 (view P). Open (1) hole to 11/16" (0.688) for the handle	<i>ml</i>	03-09-08	1
6	CA	Drill Pilot holes Ø(#30) using drill Jig D3144-T1, and mark slot opening. Cut slot in (2) places per mark as per Dwg D412-694 page 4 (view P) and page 2.	<i>ml</i>	03-09-22	1
7	CA	Drill (4) pilot holes Ø(#30) for D3151-041 doubler assembly and (12) holes Ø(#30) for D3162-041 bracket using drill Jig D3162-041T1 as per Dwg D412-694 page 4 (view P).	<i>ml</i>	03-10-20	1
8	CA	Open (3) holes to Ø 19/32" (0.593) at top and (3) at bottom for insert as per Dwg D412-694 page 4 (view P).	<i>ml</i>	03-09-10	1
9	CA	Drill Pilot holes Ø(#30) for rollers using drill Jig DT8703-1A. Open holes to Ø 19/32 (0.593) for inserts as per Dwg D412-694 page 2, page 6 (view K, L, M, Q). Q-K-L-M	<i>ml</i>	03-09-08	1
10	CA	Drill Pilot holes Ø(#30) for rollers using drill Jig DT8703-1B. Open holes to Ø 19/32 (0.593) for inserts as per Dwg D412-694 page 2, page 6 (view H, J).	<i>ml</i>	03-09-10	1
11	CA	Drill (27) pilot holes Ø(#30) using drill Jig B30-23000-211LH for D3126 brackets as per Dwg D412-694 page 2 (view G-G). Open holes Ø 19/32 (0.593) for insert.	<i>ml</i>	03-09-10	1
12	CA	Open Ø(#19) and C sink Ø 0.332 x 100° from the far side (3) holes for each D3155-041/-042 bracket assembly as per D412-694 page 4 (view P).	<i>ml</i>	03 10 17	1
13	QC5	Inspect work to Step 12	<i>[Signature]</i>	03-12-18	1
14	CA	Place D412-694-01 and D412-694-03 in the mold DT N/A Trace slots from the big door to the small door. <b>Ensure proper alignment.</b>	<i>ml</i>	03-10-15	1
15	CA	Remove both doors from the mold.	<i>ml</i>	03-10-15	1
16	CA	Drill pilot holes Ø(#30) using drill Jig D3144-T3. Ensure slot is aligned with mark as per Dwg D412-694 page 3.	<i>[Signature]</i>	03.10.15	1
17	CA	Open slot as per mark.	<i>ml</i>	03-10-15	1
18	CA	Open (4) holes Ø 0.191" for D3150 guide as per Dwg D412-694 page 5 (view CC and DD)	<i>ml</i>	03-11-17	1
19	CA	Drill pilot holes for cover Ø(#30) using drill Jig D3119-041T3A, D3119-041T3B and D3119-041T3C holding the Jig by cleco using hole from step 16. Open holes for the cover to Ø 0.433 for inserts as per Dwg D412-694 page 3.	<i>ml</i>	03-11-25	1

Step 5  
Step 9  
Specify: do not pass thru it for insert

Bracket Assy update P/O

PRELIMINARY  
ISSUE

# Roller Bracket Update

①

update Roller brackets as  
per DSF 9274

~~exchange~~

D3212-241

B20779

D3183-05

B<sup>20533</sup>~~20430~~

D3183-7

B20430

D3121-21

B20778 B



01.10.27

②

exchange D3121-044

Ser D3121-041

B#



01.10.27

↑  
SER W/O 21819

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
<b>Description: Door Assembly</b>	<b>Part Number:</b>	<b>D412-694-01</b>
		<b>D412-694-03</b>
<b>Dwg: D412-694 Rev. A page 2, 3, 4, 5, 6; D3140 Rev. B</b>	<b>Qty:</b>	
		<b>Page 2 of 8</b>

Step	Location	Procedure	By	Date	Qty
20	CA	Drill (4) pilot holes Ø(#30) using drill Jig D3111-041T3 as per Dwg D412-694 page 5 (view W). Open holes to Ø 0.193-0.197 and c'sink Ø 0.385 x 100° from the far side of the door for D3111-041 plate assembly.	ml	03-10-23	1
21	CA ✓	Drill pilot holes Ø(#30) using drill Jig D3120-3T3 for bottom cover. and <del>D3120-1T1 for top cover</del> . Open holes to Ø 19/32 (0.593) for inserts as per Dwg D412-694 page 3. <del>D3120-1T1</del> <i>DT8703-3A</i>	ml	03-10-23	1
22	CA ✓	Drill pilot holes Ø(#30) using drill Jig <del>D3146-1T1</del> for hinges. Open holes to Ø 19/32 (0.593) for inserts as per Dwg D412-694 page 3, page 4 (view MM-MM)	ml	03-10-23	1
23	CA	Drill pilot holes Ø(#30) using drill Jig D3142-041T3 for window.		N/A	1
24	CA ✓	Drill through hole Ø 5/8 (0.625) and pilot drill Ø (#30) using drill Jig D3112-1T3A for the top. Open holes to Ø 19/32 (0.593) for clevis inserts at top as per Dwg D412-694 page 5 (section AA-AA)	ml	03-11-03	1
25	CA ✓	Drill through hole Ø 5/8 (0.625) and pilot drill Ø (#30) using drill Jig D3112-1T3B for clevis insert at bottom. Open holes to Ø 19/32 (0.593) for clevis inserts at top as per Dwg D412-694 page 5 (section AA-AA)	ml	03-11-03	1
26	CA ✓	Router slot for D3112-1 guide using tool D3112-1T3C at bottom as per Dwg D412-694 page 5 (section AA-AA). <del>0.210" deep</del>	ml	03-11-03	1
27A	CA ✓	Router slot for D3112-1 guide using tool D3112-1T3D at top as per Dwg D412-694 page 5 (section AA-AA). <del>0.210" deep</del>	ml	03-11-03	1
28	CA	Drill pilot holes Ø(#30) for D3114 pivot using drill Jig D3114-1T3. Open holes to Ø 19/32 (0.593) for inserts as per Dwg D412-694 page 4 (view MM-MM)	ml	03-11-03	1
29	CA	Drill (1) Ø(#10) 0.193 for clevis base at top and (2) Ø(#19) 0.166 for stop using drill Jig D3130-1T3 as per Dwg D412-694 page 5 (section FF-FF)	ml	03-10-29	1
30	CA ✓	Drill Ø(#10) 0.193 for clevis base at bottom as per Dwg D412-694 page 5 (section FF-FF)	ml	03-10-29	1
31	QC5 ✓	Inspect work to Step 30	RF	03-12-18	1
32	CA ✓	Install inserts as per Dwg D412-694 page 2 (view G-G); page 6 (view H, J, K, L, M, Q). <b>Pick: (for D412-694-01)</b> Qty Part Number Description Batch 65 80-005-2-8 Insert M11762 12073-1700 Epocast-50A M13770-M12962 Install inserts as per Dwg D412-694 page 3 & 5 (section AA-AA) and page 4 (view MM-MM). <b>Pick: (for D412-694-03)</b> Qty Part Number Description Batch 21 80-005-2-8 Insert M11762 12 SL607-06-9S Insert N/A 12073-1700 Epocast-50A M13770-M12962	ml	03-11-26	1
33	CA	Install D3162-041 as per Dwg D412-694 page 4 (view R-R and S-S) and D3156-1 bracket as per (view T-T and U-U). <b>Pick:</b> Qty Part Number Description Batch 2 D3156-1 Bracket M10536-17 12 D3162-041 Bracket Assembly B17445 12 M7885/2-4-3 Rivet M6733 16 MS20426AD4-7 Rivet M12655	ml	03-10-17	1

PRELIMINARY ISSUE PTO

use Seal

03.12.18

PTO

Step 35: Scrap 1x3116-5-0680

#	27B	CA	(2) Shear blanks 0.650" x 2.650" Material: 2024-T3 (QQ-A-250/4) 0.040" thick Batch: M12759	RF	03-10-25	2
	27C	WA	Tag spot point on three location for guide the plate Deburr. spot point high 0.030"	ml	03/10/25	2
	27D	FP	Chemical conversion as per CSI 005 4.1	J	031025	2
	27E	CA	install plate with Hysol EA934NA fill slot leave Bond 0.050 from top surface. Note Top and bottom AR Hysol EA934NA Batch: M13770 - M12962 <del>Batch: M13270</del>	ml	03-11-7	2
	27F	CA	Router D3112-1 guide to the depth 0.150 from the top surface check with D3112-1 to fit	ml	03-11-14	2
	32B	EA				

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
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			<b>D412-694-03</b>
<b>Dwg:</b> D412-694 Rev. A page 2, 3, 4, 5, 6; D3140 Rev. B		<b>Qty:</b>	
		<b>Page 3 of 8</b>	

Step	Location	Procedure	By	Date	Qty																																																																																																								
34	CA	Install Doubler as per Dwg D412-694 page 4 (view P) <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3151041</td><td>Doubler</td><td>M10536-17</td></tr><tr><td>4</td><td>MS20426AD4-6</td><td>Rivet</td><td>M2566</td></tr></table>	Qty	Part Number	Description	Batch	1	D3151041	Doubler	M10536-17	4	MS20426AD4-6	Rivet	M2566	ml	03-10-02	1																																																																																												
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35	CA	<b>D412-694-01 Installation</b> Install Doublers to door as per Dwg D412-694 page 2 (section V-V). Bond D3116-7-0680 Seal with 1440B-1/2 Sealant as per Dwg D412-694 page 2 (view V-V and N). Transfer slot opening in the seal. <b>Pick:</b> BSP46 Rivet M12330 <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3116-7-0680</td><td>Seal</td><td>B17462</td></tr><tr><td>1</td><td>D3144-3</td><td>Doubler</td><td>B18816</td></tr><tr><td>1</td><td>D3144-8109</td><td>Doubler M10090</td><td>M10090</td></tr><tr><td>1</td><td>D3144-11111</td><td>Doubler M10090</td><td>M10090</td></tr><tr><td>3</td><td>BSP45</td><td>Rivet</td><td>M11821</td></tr></table>	Qty	Part Number	Description	Batch	1	D3116-7-0680	Seal	B17462	1	D3144-3	Doubler	B18816	1	D3144-8109	Doubler M10090	M10090	1	D3144-11111	Doubler M10090	M10090	3	BSP45	Rivet	M11821	ml	03-10-02	1																																																																																
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36	CA	Assemble D3123-1 Cam with D3124-1/-2 Hook and Rod Weldment. Install D3155-041/-042 Assembly. Connect Rod Weldments to D3122-1 Lever and D3127-1 Spacer. Install D3141-1 Spring as per Dwg D412-694 page 4 (view P). <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3122-1</td><td>Lever</td><td>M10536-17</td></tr><tr><td>2</td><td>D3123-1</td><td>Cam</td><td>M10536-17</td></tr><tr><td>1</td><td>D3124-1</td><td>Hook</td><td>M10536-17</td></tr><tr><td>1</td><td>D3124-2</td><td>Hook</td><td>M10536-17</td></tr><tr><td>1</td><td>D3127-1</td><td>Spacer</td><td>B17784</td></tr><tr><td>1</td><td>D3132-041</td><td>Rod Weldment</td><td>M10536-17</td></tr><tr><td>1</td><td>D3133-041</td><td>Rod Weldment</td><td>M10536-17</td></tr><tr><td>2</td><td>D3141-1</td><td>Spring B18638</td><td>B18638</td></tr><tr><td>2</td><td>D3148-1</td><td>Clevis</td><td>M10536-17</td></tr><tr><td>1</td><td>D3155-041</td><td>Bracket Assembly</td><td>M10536-17</td></tr><tr><td>1</td><td>D3155-042</td><td>Bracket Assembly</td><td>M10536-17</td></tr><tr><td>4</td><td>AN960JD10L</td><td>Washer</td><td>M12749</td></tr><tr><td>2</td><td>AN960JD416L</td><td>Washer</td><td>M3154</td></tr><tr><td>6</td><td>AN960JD8</td><td>Washer</td><td>M9636</td></tr><tr><td>2</td><td>MS20392-2C17</td><td>Pin</td><td>M11735</td></tr><tr><td>2</td><td>MS20392-2C9</td><td>Pin</td><td>M11784</td></tr><tr><td>2</td><td>MS20392-3C21</td><td>Pin</td><td>M11765</td></tr><tr><td>2</td><td>MS20995-C20</td><td>Lockwire</td><td>N/A FOR THIS TIME</td></tr><tr><td>6</td><td>MS21042L08</td><td>Nut (or -8)</td><td>12790</td></tr><tr><td>6</td><td>MS24665-151</td><td>Cotter Pin</td><td>M11735</td></tr><tr><td>6</td><td>MS24694-S5</td><td>Screw</td><td>M11735</td></tr><tr><td>2</td><td>MS35275-233</td><td>Screw</td><td>M11822</td></tr><tr><td>2</td><td>MS35649-264</td><td>Nut</td><td>M11822</td></tr><tr><td>2</td><td>MS35650-3252</td><td>Nut</td><td>M11735</td></tr><tr><td>2</td><td>MS51859-7</td><td>Washer</td><td>M11822</td></tr></table>	Qty	Part Number	Description	Batch	1	D3122-1	Lever	M10536-17	2	D3123-1	Cam	M10536-17	1	D3124-1	Hook	M10536-17	1	D3124-2	Hook	M10536-17	1	D3127-1	Spacer	B17784	1	D3132-041	Rod Weldment	M10536-17	1	D3133-041	Rod Weldment	M10536-17	2	D3141-1	Spring B18638	B18638	2	D3148-1	Clevis	M10536-17	1	D3155-041	Bracket Assembly	M10536-17	1	D3155-042	Bracket Assembly	M10536-17	4	AN960JD10L	Washer	M12749	2	AN960JD416L	Washer	M3154	6	AN960JD8	Washer	M9636	2	MS20392-2C17	Pin	M11735	2	MS20392-2C9	Pin	M11784	2	MS20392-3C21	Pin	M11765	2	MS20995-C20	Lockwire	N/A FOR THIS TIME	6	MS21042L08	Nut (or -8)	12790	6	MS24665-151	Cotter Pin	M11735	6	MS24694-S5	Screw	M11735	2	MS35275-233	Screw	M11822	2	MS35649-264	Nut	M11822	2	MS35650-3252	Nut	M11735	2	MS51859-7	Washer	M11822	ml	04-01-08	
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4	AN960JD10L	Washer	M12749																																																																																																										
2	AN960JD416L	Washer	M3154																																																																																																										
6	AN960JD8	Washer	M9636																																																																																																										
2	MS20392-2C17	Pin	M11735																																																																																																										
2	MS20392-2C9	Pin	M11784																																																																																																										
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**PRELIMINARY  
ISSUE**

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
<b>Description:</b> Door Assembly	<b>Part Number:</b>	<b>D412-694-01</b>
		<b>D412-694-03</b>
<b>Dwg:</b> D412-694 Rev. A page 2, 3, 4, 5, 6; D3140 Rev. B	<b>Qty:</b>	
		<b>Page 4 of 8</b>

Step	Location	Procedure	By	Date	Qty																																																
37	CA	<p>Install MS21072-L3 Nutplate in Cover Assembly in two places, per Guard. Install Cover Assembly , Handle Weldment and Guard on the door; Install D3110-5 Handle Assembly as per Dwg D412-694 page 2.</p> <p><b>Pick:</b></p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3110-5</td><td>Handle Assembly</td><td>m10536-17</td></tr><tr><td>1</td><td>D3135-041</td><td>Handle Weldment</td><td>B18863</td></tr><tr><td>1</td><td>D3139-1</td><td>Guard</td><td>B18863</td></tr><tr><td>1</td><td>D3139-3</td><td>Guard</td><td>B18863</td></tr><tr><td>1</td><td>D3163-041</td><td>Cover Assembly</td><td>m10536-17</td></tr><tr><td>10</td><td>AN525-10R6</td><td>Screw</td><td>m11822</td></tr><tr><td>8</td><td>AN525-10R7</td><td>Screw</td><td>m11822</td></tr><tr><td>8</td><td>MS20426AD3-3</td><td>Rivet</td><td>m1563</td></tr><tr><td>4</td><td>MS21072-L3</td><td>Nutplate</td><td>m11760</td></tr><tr><td>4</td><td>MS24693-S271</td><td>Screw</td><td>m12655</td></tr><tr><td>4</td><td>MS24694-05</td><td>Screw</td><td>m11755</td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D3110-5	Handle Assembly	m10536-17	1	D3135-041	Handle Weldment	B18863	1	D3139-1	Guard	B18863	1	D3139-3	Guard	B18863	1	D3163-041	Cover Assembly	m10536-17	10	AN525-10R6	Screw	m11822	8	AN525-10R7	Screw	m11822	8	MS20426AD3-3	Rivet	m1563	4	MS21072-L3	Nutplate	m11760	4	MS24693-S271	Screw	m12655	4	MS24694-05	Screw	m11755		03-11-10	1
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1	D3163-041	Cover Assembly	m10536-17																																																		
10	AN525-10R6	Screw	m11822																																																		
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8	MS20426AD3-3	Rivet	m1563																																																		
4	MS21072-L3	Nutplate	m11760																																																		
4	MS24693-S271	Screw	m12655																																																		
4	MS24694-05	Screw	m11755																																																		
38	CA	<p>Install and Assemble brackets as per Dwg D412-694 page 2 and 5 (view H,J,K,L,M and Q).</p> <p><b>Pick:</b></p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3115-1</td><td>Bracket</td><td>B17390</td></tr><tr><td>2</td><td>D3121-041</td><td>Bracket Assembly</td><td>m10536-17</td></tr><tr><td>1</td><td>D3121-043</td><td>Bracket Assembly</td><td>B18869</td></tr><tr><td>1</td><td>D3121-045</td><td>Bracket Assembly</td><td>B18869</td></tr><tr><td>1</td><td>D3137-041</td><td>Bracket Assembly</td><td>B18657</td></tr><tr><td>1</td><td>D3152-041</td><td>Bracket Assembly</td><td>B18867</td></tr><tr><td>1</td><td>D3183-041</td><td>Bracket Assembly</td><td>B19022</td></tr><tr><td>2</td><td>AN525-10R6</td><td>Screw</td><td>m11377</td></tr><tr><td>2</td><td>AN960JD10LL</td><td>Washer</td><td>m11763</td></tr><tr><td>18/12</td><td>MS24694-S50</td><td>Screw</td><td>m11735</td></tr><tr><td>2</td><td>MS27039-1-05</td><td>Screw</td><td>m13601</td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D3115-1	Bracket	B17390	2	D3121-041	Bracket Assembly	m10536-17	1	D3121-043	Bracket Assembly	B18869	1	D3121-045	Bracket Assembly	B18869	1	D3137-041	Bracket Assembly	B18657	1	D3152-041	Bracket Assembly	B18867	1	D3183-041	Bracket Assembly	B19022	2	AN525-10R6	Screw	m11377	2	AN960JD10LL	Washer	m11763	18/12	MS24694-S50	Screw	m11735	2	MS27039-1-05	Screw	m13601		03-12-05	1
Qty	Part Number	Description	Batch																																																		
1	D3115-1	Bracket	B17390																																																		
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1	D3121-043	Bracket Assembly	B18869																																																		
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1	D3152-041	Bracket Assembly	B18867																																																		
1	D3183-041	Bracket Assembly	B19022																																																		
2	AN525-10R6	Screw	m11377																																																		
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18/12	MS24694-S50	Screw	m11735																																																		
2	MS27039-1-05	Screw	m13601																																																		
39	CA	<p>Transfer holes using (#30) drill from D3144-13 doubler to seal and open seal holes to Ø(#24) 0.152". Install seal and doubler to door. Ensure D3116-9-0770 is properly aligned as per Dwg D412-694 page 2 (section NN-NN).</p> <p><b>Pick:</b></p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3116-9-0770</td><td>Seal</td><td>B17463</td></tr><tr><td>1</td><td>D3144-13</td><td>Doubler</td><td>m10536-17</td></tr><tr><td>37</td><td>BSP45</td><td>Rivet</td><td>m11821</td></tr><tr><td>2</td><td>M7885/3-4-3</td><td>Rivet</td><td>m11872</td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D3116-9-0770	Seal	B17463	1	D3144-13	Doubler	m10536-17	37	BSP45	Rivet	m11821	2	M7885/3-4-3	Rivet	m11872		03-11-10	1																												
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1	D3144-13	Doubler	m10536-17																																																		
37	BSP45	Rivet	m11821																																																		
2	M7885/3-4-3	Rivet	m11872																																																		

CHECK ON D3144-13 ONE HOLE MISSING

**PRELIMINARY  
ISSUE**

Step 38 : Make plate to fire D3183-041

6061T-6 - 2" x 2.160 BATCH M3932 + ALODINE  
change screw by MS 24694-54-3 QTY BATCH  
3 M9599

Make plate to fire D3137-041

6061T-6 - 2" x 2.20" BATCH M3932 + ALODINE  
change screw by MS 24694-54-3 QTY BATCH  
3 M9599

ADD THESE PARTS TO THE FRONT

BY	DATE	QTY
ml	03-12-14	1
ml	03-12-14	1

H

Handwritten scribbles and marks.

Handwritten mark.

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
<b>Description:</b> Door Assembly	<b>Part Number:</b>	<b>D412-694-01</b>
		<b>D412-694-03</b>
<b>Dwg:</b> D412-694 Rev. A page 2, 3, 4, 5, 6; D3140 Rev. B	<b>Qty:</b>	
		<b>Page 5 of 8</b>

Step	Location	Procedure	By	Date	Qty																																												
40	CA	Install D3126 Brackets and D3138 Cover as per Dwg D412-694 page 2 (view G-G and NN-NN). <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3126-1</td><td>Bracket</td><td>B18656B</td></tr><tr><td>1</td><td>D3126-3</td><td>Bracket</td><td>B18657</td></tr><tr><td>5</td><td>D3126-5</td><td>Bracket</td><td>B18658H</td></tr><tr><td>1</td><td>D3138-1</td><td>Cover M10715</td><td><del>B17437B</del></td></tr><tr><td>14</td><td>AN960JD10L</td><td>Washer</td><td>M10749</td></tr><tr><td>13</td><td>AN960JD10LL</td><td>Washer</td><td>M11763</td></tr><tr><td>14</td><td>MS27039-1-06</td><td>Screw</td><td>M11754</td></tr><tr><td>13</td><td>MS27039-1-08</td><td>Screw</td><td>M13356</td></tr><tr><td>7</td><td>NAS43DD3-10</td><td>Spacer</td><td>M11764</td></tr><tr><td>6</td><td>NAS43DD3-14</td><td>Spacer</td><td>M11785</td></tr></table>	Qty	Part Number	Description	Batch	1	D3126-1	Bracket	B18656B	1	D3126-3	Bracket	B18657	5	D3126-5	Bracket	B18658H	1	D3138-1	Cover M10715	<del>B17437B</del>	14	AN960JD10L	Washer	M10749	13	AN960JD10LL	Washer	M11763	14	MS27039-1-06	Screw	M11754	13	MS27039-1-08	Screw	M13356	7	NAS43DD3-10	Spacer	M11764	6	NAS43DD3-14	Spacer	M11785	mul	03-11-28	1
Qty	Part Number	Description	Batch																																														
1	D3126-1	Bracket	B18656B																																														
1	D3126-3	Bracket	B18657																																														
5	D3126-5	Bracket	B18658H																																														
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7	NAS43DD3-10	Spacer	M11764																																														
6	NAS43DD3-14	Spacer	M11785																																														
41	CA	<b>D412-694-03 Installation</b> Install brackets as per Dwg D412-694 page 5 (view W) and (section LL-LL). <i>INSTALL WITH SEAL</i> <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3159-041</td><td>Bracket Assembly</td><td>B18641</td></tr><tr><td>1</td><td>D3159-043</td><td>Bracket Assembly</td><td>B17420</td></tr><tr><td>1</td><td>M7885/3-4-15</td><td>Rivet</td><td>M1108</td></tr><tr><td>2</td><td>M7885/3-4-4</td><td>Rivet</td><td>M9163</td></tr></table>	Qty	Part Number	Description	Batch	1	D3159-041	Bracket Assembly	B18641	1	D3159-043	Bracket Assembly	B17420	1	M7885/3-4-15	Rivet	M1108	2	M7885/3-4-4	Rivet	M9163	mul	03-11-17	1																								
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2	M7885/3-4-4	Rivet	M9163																																														
42	CA	Install Doublers. Cut slot openings to D3116-5-0680 Seal as per Dwg D412-694 page 3 (section JJ-JJ) <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3116-5-0680</td><td>Seal</td><td>B17304</td></tr><tr><td>1</td><td>D3144-1</td><td>Doubler</td><td>B18816</td></tr><tr><td>1</td><td>D3144-105</td><td>Doubler M10090</td><td>B18816</td></tr><tr><td>1</td><td>D3144-107</td><td>Doubler M10090</td><td>B18816</td></tr><tr><td>1</td><td>BSP45</td><td>Rivet</td><td>M11821</td></tr></table>	Qty	Part Number	Description	Batch	1	D3116-5-0680	Seal	B17304	1	D3144-1	Doubler	B18816	1	D3144-105	Doubler M10090	B18816	1	D3144-107	Doubler M10090	B18816	1	BSP45	Rivet	M11821	mul	03-11-17	1																				
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1	D3144-107	Doubler M10090	B18816																																														
1	BSP45	Rivet	M11821																																														
43	CA	Install D3150-1 Guide to Door as per Dwg D412-694 page 5 (view DD & CC) <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D3128-1</td><td>Shim</td><td>B18643</td></tr><tr><td>2</td><td>D3149-1</td><td>Striker Plate</td><td>M1053617</td></tr><tr><td>2</td><td>D3150-1</td><td>Guide</td><td>M10536-17</td></tr><tr><td>4</td><td>AN960JD10LL</td><td>Washer</td><td>M11763</td></tr><tr><td>4</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M11492</td></tr><tr><td>4</td><td>MS24694-S54</td><td>Screw</td><td>M9599</td></tr></table>	Qty	Part Number	Description	Batch	2	D3128-1	Shim	B18643	2	D3149-1	Striker Plate	M1053617	2	D3150-1	Guide	M10536-17	4	AN960JD10LL	Washer	M11763	4	MS21042L3	Nut (or -3)	M11492	4	MS24694-S54	Screw	M9599	mul	03-11-17	1																
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4	MS21042L3	Nut (or -3)	M11492																																														
4	MS24694-S54	Screw	M9599																																														
44	QC5	Inspect work to Step 43	#	03.12.18	1																																												
45	CA	Install D3112-1 Guide. Allow D3112-1 to move freely for adjustment per Dwg D412-694 page 5 (section X-X; Y-Y; AA-AA). <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D3112-1</td><td>Guide</td><td>B18427</td></tr></table>	Qty	Part Number	Description	Batch	2	D3112-1	Guide	B18427	mul	03-11-15	1																																				
Qty	Part Number	Description	Batch																																														
2	D3112-1	Guide	B18427																																														

PTO

#

PTO

Step 42: Made D3144-107  
D3144-105

gato paint cell for Powder coat Black

MADE 1 plate 0.740 x 1.650

SOS2 BAR M 9674 / TICKNESS .125

FOR FIT WITH HOLE ON COVER

OPERATOR MISTAKE

**PRELIMINARY  
ISSUE**



By	Location	Procedure	By	Date	Qty	
	42A	FP	Chemical conversion <sup>coat</sup> as per Q51 005 4.1 D3144-111/-109/-107/-105	MM	03.10.29	4
	42B	FP	Powder Coat black Sandtex (4.3.5.7) as per Q51 005 4.3 D3144-111/-109/-107/-105	MM	03.10.29	4
	42C	QC3	Inspect work to step 42B	HT	03.10.29	4
	40A	6A	Cut (2) blanks 4.00" x 78.00" as per Dwg D3138. Grain along 78.00" Material: S052-H34 (QQ-A-250/ ), 0.032" thick (MS052H34S,032)  Identify (1) for D3138-1 (1) for D3138-2  Batch: <u>M12.715</u>	HT	03.11.25	2
	40B	GA	Deburr	HT	03.11.25	2
	40C	GA	Form as per Dwg D3138 (1) for D3138-1 (1) for D3138-2 Identify properly	SB	03/11/27	2
	40D	QC5	Inspect work to step 40C	AB	03.11.27	2
	40E	FP	Chemical conversion coat per Q51 005 4.1	MM	03.11.27	2
	40F	FP	Powder Coat Grey Sandtex (Ref. 4.3.5.6) per Q51 005 4.3	MM	03.11.27	2
	40G	QC3	Inspect powder Coat	Q	03.11.28	2

HT

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
<b>Description:</b> Door Assembly	<b>Part Number:</b>	<b>D412-694-01</b>
		<b>D412-694-03</b>
<b>Dwg:</b> D412-694 Rev. A page 2, 3, 4, 5, 6; D3140 Rev. B	<b>Qty:</b>	
		<b>Page 6 of 8</b>

Step	Location	Procedure	By	Date	Qty																																																																				
46	CA	<p>Install D3130-1 Clevis Base and D3131-1 Stop. Assemble D3125-1 Lever with D3147 Pin as per Dwg D412-694 page 5 (section FF-FF &amp; AA-AA)</p> <p>Pick: 2 AN960J08 Washer M9636 2 AN960J08L Washer M6956</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3125-1</td><td>Lever</td><td>M10536-17</td></tr><tr><td>1</td><td>D3125-7</td><td>Lever</td><td>M10536-17</td></tr><tr><td>2</td><td>D3130-1</td><td>Clevis Base</td><td>M10536-17</td></tr><tr><td>1</td><td>D3131-1</td><td>Stop</td><td>M10536-17</td></tr><tr><td>2</td><td>D3147-1</td><td>Pin</td><td>M10536-17</td></tr><tr><td>4</td><td>AN525-10R7</td><td>Screw</td><td>M11822</td></tr><tr><td>4</td><td>AN960JD6L</td><td>Washer</td><td>M5519</td></tr><tr><td>2 add</td><td>AN960JD10LL</td><td>Washer</td><td>M11763</td></tr><tr><td><del>12</del></td><td><del>AN960JD416L</del></td><td><del>Washer</del></td><td><del>M3154</del></td></tr><tr><td>12</td><td>FW4-032</td><td>Washer</td><td>M11822</td></tr><tr><td>2</td><td>MS20392-1C11</td><td>Pin</td><td>M11735</td></tr><tr><td>2</td><td>MS21042L06</td><td>Nut (or -6)</td><td>M11492</td></tr><tr><td>2+2</td><td>MS24665-151</td><td>Cotter Pin</td><td>M11735</td></tr><tr><td>2</td><td>MS27039-1-05</td><td>Screw</td><td>M3501</td></tr><tr><td>2</td><td>MS35206-231</td><td>Screw</td><td>M11735</td></tr><tr><td>1</td><td>MS27039-1-08</td><td>Screw</td><td>M13356</td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D3125-1	Lever	M10536-17	1	D3125-7	Lever	M10536-17	2	D3130-1	Clevis Base	M10536-17	1	D3131-1	Stop	M10536-17	2	D3147-1	Pin	M10536-17	4	AN525-10R7	Screw	M11822	4	AN960JD6L	Washer	M5519	2 add	AN960JD10LL	Washer	M11763	<del>12</del>	<del>AN960JD416L</del>	<del>Washer</del>	<del>M3154</del>	12	FW4-032	Washer	M11822	2	MS20392-1C11	Pin	M11735	2	MS21042L06	Nut (or -6)	M11492	2+2	MS24665-151	Cotter Pin	M11735	2	MS27039-1-05	Screw	M3501	2	MS35206-231	Screw	M11735	1	MS27039-1-08	Screw	M13356		03-11-21	1
Qty	Part Number	Description	Batch																																																																						
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1	D3125-7	Lever	M10536-17																																																																						
2	D3130-1	Clevis Base	M10536-17																																																																						
1	D3131-1	Stop	M10536-17																																																																						
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2 add	AN960JD10LL	Washer	M11763																																																																						
<del>12</del>	<del>AN960JD416L</del>	<del>Washer</del>	<del>M3154</del>																																																																						
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47	CA	<p>Install D3111-041 Plate Assembly. If needed, install temporary D3110-3 Handle as per Dwg D412-694 page 5 (view W and section BB-BB).</p> <p>Pick:</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3111-041</td><td>Plate Assembly</td><td>M10536-17</td></tr><tr><td>1</td><td>D3125-3</td><td>Lever</td><td>M10536-17</td></tr><tr><td>1</td><td>D3125-5</td><td>Lever</td><td>M10536-17</td></tr><tr><td>2</td><td>D3129-1</td><td>Lever</td><td>M10536-17</td></tr><tr><td>2</td><td>D3157-1</td><td>Spacer</td><td>M10536-17</td></tr><tr><td>4</td><td>AN960JD10LL</td><td>Washer</td><td>M11763</td></tr><tr><td>4</td><td>FW10-032</td><td>Washer</td><td>M11822</td></tr><tr><td>2</td><td>MS20392-2C9</td><td>Pin</td><td>M11796</td></tr><tr><td>2</td><td>MS24665-151</td><td>Cotter Pin</td><td>M11735</td></tr><tr><td>2</td><td>MS24694-358</td><td>Screw</td><td>M11735</td></tr><tr><td>4</td><td>MS24694-S60</td><td>Screw</td><td>M11766</td></tr><tr><td>2</td><td>NAS1169-10L</td><td>Washer</td><td>M11753</td></tr><tr><td>2</td><td>NAS43DD3-40</td><td>Spacer</td><td>M11737</td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D3111-041	Plate Assembly	M10536-17	1	D3125-3	Lever	M10536-17	1	D3125-5	Lever	M10536-17	2	D3129-1	Lever	M10536-17	2	D3157-1	Spacer	M10536-17	4	AN960JD10LL	Washer	M11763	4	FW10-032	Washer	M11822	2	MS20392-2C9	Pin	M11796	2	MS24665-151	Cotter Pin	M11735	2	MS24694-358	Screw	M11735	4	MS24694-S60	Screw	M11766	2	NAS1169-10L	Washer	M11753	2	NAS43DD3-40	Spacer	M11737		03-10-15	1												
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2	NAS1169-10L	Washer	M11753																																																																						
2	NAS43DD3-40	Spacer	M11737																																																																						
48	CA	<p>Connect Rod and Levers together per Dwg D412-694 page 5 (view W &amp; section FF-FF)</p> <p>Pick:</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3134-1</td><td>Rod</td><td>B18862</td></tr><tr><td>1</td><td>D3134-3</td><td>Rod</td><td>B18376</td></tr><tr><td>1</td><td>D3143-1</td><td>Clevis</td><td>M10536-17</td></tr><tr><td>3</td><td>D3143-3</td><td>Clevis</td><td>M10536-17</td></tr><tr><td>5</td><td>AN960JD10LL</td><td>Washer</td><td>M11763</td></tr><tr><td>8</td><td>FW10-032</td><td>Washer</td><td>M11822</td></tr><tr><td>4</td><td>MS20392-2C15</td><td>Pin</td><td>M11796</td></tr><tr><td>4</td><td>MS24665-151</td><td>Cotter Pin</td><td>M11735</td></tr><tr><td>4</td><td>MS35650-305T</td><td>Nut</td><td>M11786</td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D3134-1	Rod	B18862	1	D3134-3	Rod	B18376	1	D3143-1	Clevis	M10536-17	3	D3143-3	Clevis	M10536-17	5	AN960JD10LL	Washer	M11763	8	FW10-032	Washer	M11822	4	MS20392-2C15	Pin	M11796	4	MS24665-151	Cotter Pin	M11735	4	MS35650-305T	Nut	M11786		03-10-15	1																												
Qty	Part Number	Description	Batch																																																																						
1	D3134-1	Rod	B18862																																																																						
1	D3134-3	Rod	B18376																																																																						
1	D3143-1	Clevis	M10536-17																																																																						
3	D3143-3	Clevis	M10536-17																																																																						
5	AN960JD10LL	Washer	M11763																																																																						
8	FW10-032	Washer	M11822																																																																						
4	MS20392-2C15	Pin	M11796																																																																						
4	MS24665-151	Cotter Pin	M11735																																																																						
4	MS35650-305T	Nut	M11786																																																																						

**PRELIMINARY  
ISSUE**

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
<b>Description:</b> Door Assembly	<b>Part Number:</b>	<b>D412-694-01</b>
		<b>D412-694-03</b>
<b>Dwg:</b> D412-694 Rev. A page 2, 3, 4, 5, 6; D3140 Rev. B	<b>Qty:</b>	
		<b>Page 7 of 8</b>

Step	Location	Procedure	By	Date	Qty																																
49	CA	Drill # 19, C'sink Ø0.332 x 100°. Install MS25281-R6 Clamp as per Dwg D412-694 page 5 (view W). Ensure Rod moves freely when installing clamps. <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>AN960JD8</td><td>Washer</td><td>m 9636</td></tr><tr><td>2</td><td>MS21042L08</td><td>Nut (or -8)</td><td>m 13935</td></tr><tr><td>2</td><td>MS24694-S 51</td><td>Screw</td><td>m 9370</td></tr><tr><td>2</td><td>MS25281-R6</td><td>Clamp</td><td>m 11759</td></tr></table>	Qty	Part Number	Description	Batch	2	AN960JD8	Washer	m 9636	2	MS21042L08	Nut (or -8)	m 13935	2	MS24694-S 51	Screw	m 9370	2	MS25281-R6	Clamp	m 11759	ml	03-11-21	1												
Qty	Part Number	Description	Batch																																		
2	AN960JD8	Washer	m 9636																																		
2	MS21042L08	Nut (or -8)	m 13935																																		
2	MS24694-S 51	Screw	m 9370																																		
2	MS25281-R6	Clamp	m 11759																																		
50	QC5	Inspect work to Step 49	RF	03.12.18	1																																
51	CA	Install Hinge Bracket and D3113-1 Spring as per Dwg D412-694 page 3 & 4 (view MM-MM) <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3113-1</td><td>Spring</td><td>B17437</td></tr><tr><td>1</td><td>D3114-1</td><td>Pivot</td><td>B18630</td></tr><tr><td>1</td><td>D3145-1</td><td>Bracket</td><td>B189018</td></tr><tr><td>1</td><td>D3146-1</td><td>Bracket</td><td>M10536-17</td></tr><tr><td>6</td><td>AN960JD10LL</td><td>Washer</td><td>M11763</td></tr><tr><td>6</td><td>MS27039-1-08</td><td>Screw</td><td>M13356</td></tr><tr><td>A/R</td><td>14408-1/2</td><td>Sealant</td><td></td></tr></table> <b>Expiry Date:</b> July 2004	Qty	Part Number	Description	Batch	1	D3113-1	Spring	B17437	1	D3114-1	Pivot	B18630	1	D3145-1	Bracket	B189018	1	D3146-1	Bracket	M10536-17	6	AN960JD10LL	Washer	M11763	6	MS27039-1-08	Screw	M13356	A/R	14408-1/2	Sealant		ml	03-11-26 N/A FOR THIS TIME	1
Qty	Part Number	Description	Batch																																		
1	D3113-1	Spring	B17437																																		
1	D3114-1	Pivot	B18630																																		
1	D3145-1	Bracket	B189018																																		
1	D3146-1	Bracket	M10536-17																																		
6	AN960JD10LL	Washer	M11763																																		
6	MS27039-1-08	Screw	M13356																																		
A/R	14408-1/2	Sealant																																			
52	CA	Install Covers. Attach D3116-11-0180 Seal as per Dwg D412-694 page 3 <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3116-11-0180</td><td>Seal</td><td>B17441</td></tr><tr><td>1</td><td>D3120-1</td><td>Cover</td><td>M10536-17</td></tr><tr><td>1</td><td>D3120-3</td><td>Cover</td><td>M10536-17</td></tr><tr><td>10</td><td>AN960JD10LL</td><td>Washer</td><td>M11763</td></tr><tr><td>10</td><td>MS27039-1-06</td><td>Screw</td><td>M11754</td></tr><tr><td>A/R</td><td>732 RTV Clear</td><td>Sealant</td><td>M11953</td></tr></table> <b>Expiry Date:</b> July 2004	Qty	Part Number	Description	Batch	1	D3116-11-0180	Seal	B17441	1	D3120-1	Cover	M10536-17	1	D3120-3	Cover	M10536-17	10	AN960JD10LL	Washer	M11763	10	MS27039-1-06	Screw	M11754	A/R	732 RTV Clear	Sealant	M11953	ml	03-11-26	1				
Qty	Part Number	Description	Batch																																		
1	D3116-11-0180	Seal	B17441																																		
1	D3120-1	Cover	M10536-17																																		
1	D3120-3	Cover	M10536-17																																		
10	AN960JD10LL	Washer	M11763																																		
10	MS27039-1-06	Screw	M11754																																		
A/R	732 RTV Clear	Sealant	M11953																																		
53	CA	Install D3142-041 Window Mod to the Door as per Dwg D412-694 page 3 <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3142-041</td><td>Window Mod</td><td></td></tr><tr><td>72</td><td>AN960JD4</td><td>Washer</td><td></td></tr><tr><td>72</td><td>MS20600AD4W5</td><td>Rivet</td><td></td></tr></table>	Qty	Part Number	Description	Batch	1	D3142-041	Window Mod		72	AN960JD4	Washer		72	MS20600AD4W5	Rivet			N/A RF 04.01.08																	
Qty	Part Number	Description	Batch																																		
1	D3142-041	Window Mod																																			
72	AN960JD4	Washer																																			
72	MS20600AD4W5	Rivet																																			

53A	CA	<p>D2126-0730 seal B19210</p> <p>Cut <sup>(1)</sup> D3241-1 window as per template (24.50x13.50)</p> <p>D3241-1T1</p> <p>Material: M-ACRYLIC-S-125 (1/8" ACRYLIC SHEET)</p> <p>Batch: M14111</p> <p><b>PRELIMINARY ISSUE</b></p>	RF	03.12.16	1
53B	CA	Deburr	RF	03.12.16	1

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
<b>Description:</b> Door Assembly	<b>Part Number:</b>	<b>D412-694-01</b>
		<b>D412-694-03</b>
<b>Dwg:</b> D412-694 Rev. A page 2, 3, 4, 5, 6; D3140 Rev. B	<b>Qty:</b>	
		<b>Page 8 of 8</b>

Step	Location	Procedure	By	Date	Qty																																																
54	CA	Install D3119-041 Cover by transfer drill from Door to Cover. Assemble Handle as per Dwg D412-694 page 3 & 5 (section BB-BB). Align properly. <b>Pick:</b> 2 MS24693C48 SCREW M12620 <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3110-1</td><td>Escutcheon</td><td>B17570</td></tr><tr><td>1</td><td>D3110-3</td><td>Handle</td><td>B17293</td></tr><tr><td>1</td><td>D3119-041</td><td>Cover Assembly</td><td>B19301</td></tr><tr><td>1</td><td>D3154-1</td><td>Key</td><td>B M 10536-17</td></tr><tr><td>1</td><td>AN960JD10LL</td><td>Washer</td><td>M 11763</td></tr><tr><td>1</td><td>MS21042L3</td><td>Nut (or -3)</td><td>N 2737</td></tr><tr><td>2</td><td>MS24693-S51</td><td>Screw</td><td>M 11755</td></tr><tr><td>3</td><td>MS51859-7</td><td>Washer</td><td>M 11822</td></tr><tr><td>16</td><td>NAS388-6-8P</td><td>Screw</td><td>M 11819</td></tr><tr><td>16</td><td>NAS391B6P</td><td>Washer</td><td>M 11761</td></tr><tr><td>10</td><td>AL 54-632-80</td><td>THIN WALL INSERT</td><td>M 13869</td></tr></table> add Note on step 59	Qty	Part Number	Description	Batch	1	D3110-1	Escutcheon	B17570	1	D3110-3	Handle	B17293	1	D3119-041	Cover Assembly	B19301	1	D3154-1	Key	B M 10536-17	1	AN960JD10LL	Washer	M 11763	1	MS21042L3	Nut (or -3)	N 2737	2	MS24693-S51	Screw	M 11755	3	MS51859-7	Washer	M 11822	16	NAS388-6-8P	Screw	M 11819	16	NAS391B6P	Washer	M 11761	10	AL 54-632-80	THIN WALL INSERT	M 13869		03-11-24	1
Qty	Part Number	Description	Batch																																																		
1	D3110-1	Escutcheon	B17570																																																		
1	D3110-3	Handle	B17293																																																		
1	D3119-041	Cover Assembly	B19301																																																		
1	D3154-1	Key	B M 10536-17																																																		
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10	AL 54-632-80	THIN WALL INSERT	M 13869																																																		
55	QC5	Inspect for 100% completeness on the W/O	RF	03.12.18	1																																																
56	KP	<b>Pick: Packing Kit</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D3090-1</td><td>Shim</td><td>B 18037</td></tr><tr><td>2</td><td>D3090-3</td><td>Shim</td><td>B 18040</td></tr><tr><td>1</td><td>D3108-1</td><td>Decal</td><td>B 18615</td></tr><tr><td>1</td><td>D3108-2</td><td>Decal</td><td>B 18626</td></tr><tr><td>2</td><td>D3108-3</td><td>Decal</td><td>B 17204</td></tr><tr><td>2</td><td>D3108-5</td><td>Decal</td><td>B 17032</td></tr><tr><td>1</td><td>D3108-7</td><td>Decal</td><td>B 18163</td></tr><tr><td>1</td><td>D3116-3-0500</td><td>Seal</td><td>B 17296</td></tr><tr><td>2</td><td>D3118-1</td><td>Sign Assembly</td><td>B M 10536-17</td></tr><tr><td>2</td><td>D3118-3</td><td>Sign Assembly</td><td>B 17773</td></tr></table>	Qty	Part Number	Description	Batch	2	D3090-1	Shim	B 18037	2	D3090-3	Shim	B 18040	1	D3108-1	Decal	B 18615	1	D3108-2	Decal	B 18626	2	D3108-3	Decal	B 17204	2	D3108-5	Decal	B 17032	1	D3108-7	Decal	B 18163	1	D3116-3-0500	Seal	B 17296	2	D3118-1	Sign Assembly	B M 10536-17	2	D3118-3	Sign Assembly	B 17773		03-12-18	1				
Qty	Part Number	Description	Batch																																																		
2	D3090-1	Shim	B 18037																																																		
2	D3090-3	Shim	B 18040																																																		
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2	D3118-1	Sign Assembly	B M 10536-17																																																		
2	D3118-3	Sign Assembly	B 17773																																																		
57	QC4	Inspect Kit for 100% completeness on the W/O		03-12-16	1																																																
58	AC	75% for D412-694-01/11727.61 Cost / part 25% for D412-694-03 3909.20	Suc	04-01-06	1																																																
59	DC	Close W/O Inspect Level 21		04.01.09	1																																																

Rev	Date	Change	Revised By	Approved
A	02.08.20	New issue	KJ/RF	

**PRELIMINARY  
ISSUE**

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	18433
<b>Description:</b> Door Assembly		<b>Part Number:</b>	D412-694-01
			D412-694-03
<b>Dwg:</b> D3140 Rev. B		<b>Qty:</b>	1
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Travellers for: D412-694-01/-03 Door Assembly D3140-5/-7 Doubler Kit <b>Dwg not required</b>	JA	03.03.10	1
2	PG	Issue P/O: <u>2005241</u> Description: D3140-05/-07 Doors <u>8 D 3119-041</u> Supplier: Delastek <u>see 5 (batch 19301/PO 2005446</u> Ship to Delastek Qty Part Number Description Batch 1 D3140-5-7 Doubler Kits <u>B184465B</u>	U	03-06-05	1
3	RG	Receive	Q	03-03-10	1
4		Inspect	JB	03-03-10	1

PRELIMINARY  
ISSUE

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 13, 2002  
04:01 pm

Work Order No : 0018433S  
Project Name : D412-694-03  
Project For : wk 48  
Work Order Type : Main  
Main WO Number :  
House Part Number : D412-694-03  
Description : Door Assembly  
Manufactured : Yes  
Amount Req'd : 1  
Amount Done : 0  
Start Date :  
Est Finish Date : 11-29-02  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Testing Hours :	0.00	0.00	0.00	0.00	0.00
Testing Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
SubContract Hours :	0.00	0.00	0.00	0.00	0.00
SubContract :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 13, 2002  
04:09 pm

Work Order No	: 0018433	Department Code:	
Project Name	: D412-694-01	Burden Flags	: NNNNNNNN
Project For	: wk 48	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D412-694-01	Invoice Number	:
Description	: Door Assembly	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 1	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	:		
Est Finish Date	: 11-29-02	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00	0.00	0.00
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00	0.00	0.00
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Testing Hours	: 0.00	0.00	0.00	0.00	0.00
Testing Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00	0.00	0.00
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
SubContract Hours	: 0.00	0.00	0.00	0.00	0.00
SubContract	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00	0.00	0.00
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====					
Burden	: 0.00	0.00	0.00		
=====					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00



Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	9088
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Ship to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #	GST/PST #		
21/02/03	05/04/02	1064	Linda Lacelle	2004397			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
4	3	✓ 1	DKA359-0007	D412-694-011 Space Door Kit Référence DKC135-0003 No. lot 4970 U de M : Each 1			
03-03-24 Did not receive so don't know who did inspection D.S.				D3140-05/06/07/08 only as your REQUEST 03 02 24			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357





**DELASTEK**

WWW.DELASTEK.COM

Delastek Inc.  
2699 St. Avenue  
Local 14, Pointe-A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Telephone: (819) 533-5788  
Warehouse: MAIN

Bill to: DART AEROSPACE LTD

1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336  
Contact: Linda Lacelle

Invoice #	9088
Customer #	DART US

Ship to: DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Ship via: Delastek Inc.		F.O.B. Origin		Terms: Net 30 days USA		Salesperson: Claude Lessard, ext. 233	
Ship date: 24/02/03	Order Date: 05/04/02	Our PO #: 1064	Order by: Linda Lacelle	Your PO #: 2004397	GST/PST #		
Order Qty	B.O. Qty	Current Ship	Item #	Item Description			
4	3	1	DKA359-0007	D412-694-011 Space Door Kit Référence DKC135-0003 D3140-05/06/07/08 ONLY AS YOUR REQUEST No. lot 4970 U de M : Each Qte 1			
				→ This shipment is made of P/N # D3119-041 and D3119-042 to complete the kit previously shipped on February 25th. SHIP - 5 - MARS - 2003 DART AEROSPACE X			

is hereby certified that all materials, process and finished items were  
controlled and tested in accordance with the requirements of the purchase  
and applicable specifications. All such records are on file at our plant  
and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date : Vendredi, 13:12:02 1:38:32 PM  
 Utilisateur : Marc Dubé

## Feuille de Procédé

Client : DK	DELASTEK (AERONAUTIQUE)	Nom Dessin : DOOR	
Numéro Job : 4970C		Numéro Article : DKC135-0008/-0009	
Numéro Soumission : 1369		Numéro Dessin : D3140	
Numéro B.A. : 8929		Projet Numéro : DKC135	
Cette fois : 13/12/02	No. B.V. :	Révision dessin : A	
Prsht Rev. : NC		Matériel : Tissu Fibercote E-761/7788	
Prem. fois : 1/1	Type :	Date Dûe : 16/07/02	Qté: 1 Udm: UNITE
Job précédente : 4969C			

Écrit par : \_\_\_\_\_

Vérifié & Approuvé par : \_\_\_\_\_

Commentaires : N° de pièce Dart Aerospace: D3140-05/-07 *Grande*  
 N° de pièce Delastek Aeronautique: DKA359-0008/-0009  
 N° de pièce Delastek Composites: DKC135-0008/-0009  
 Process Sheet Rév.: 00

Produit additionnel

Numéro Job:



# Séq.:

Machine ou Opération:

Description:

1.0

LISTE MATÉRIEL

LISTE DES MATÉRIAUX UTILISÉS



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

LISTE DES MATÉRIAUX UTILISÉS

Voir séquences 2 à 15 pour la liste de matériel nécessaire à la fabrication de cette pièce.

2.0

AMB0211

PREPERG FIBERCOTE E761/7781 roul. 50"

Commentair Qty.: 24.50 VERGE(s)/Unit Total : 24.50 VERGE(s)

PREPERG FIBERCOTE E761/7781 roul. 50"

3.0

AC0073

Tissu Blanc a Delaminer 1.5 M #3003251

Commentair Qty.: 12.0000 METRE CAR(s)/Unit Total : 12.0000 METRE CAR(s)

Tissu Blanc a Delaminer 1.5 M #3003251

4.0

AC0085

Film durisol # 3001792

Commentair Qty.: 18.0000 METRE CAR(s)/Unit Total : 18.0000 METRE CAR(s)

Film durisol # 3001792

5.0

AC0348

Feutre drainage AB1060 ép: 6mm #sap:3001752

Commentair Qty.: 18.0000 METRE CAR(s)/Unit Total : 18.0000 METRE CAR(s)

Feutre drainage AB1060 ép: 6mm #sap:3001752

6.0

AC0092

Sac à vide # sap 3001815

Commentair Qty.: 23.3000 METRE CAR(s)/Unit Total : 23.3000 METRE CAR(s)

Sac à vide # sap 3001815

7.0

AC0098

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 6.0000 RL(s)/Unit Total : 6.0000 RL(s)

Ruban à gommer jaune #: T/AT-200Y

Date: Vendredi, 13/12/02 1:38 40 PM  
 Utilisateur: Marc Dube

## Feuille de Procédé

Client : DK DELASTEK (AERONAUTIQUE)	Nom Dessin : DOOR
Numéro Job : 4970D	Numéro Article : DKC135-0010/-0011
Numéro Soumission : 1370	Numéro Dessin : D3140
Numéro B.A. : 8929	Projet Numéro : DKC135
Cette fois : 13/12/02 No. B.V. :	Révision dessin : A
Prsht Rev. : NC	Matériel : Tissu Fibercote E-761/7788
Prem. fois : 11 Type :	Date Due : 16/07/02 Qté: 1 Udm: UNITE
Job précédente : 4969D	

 Écrit par : \_\_\_\_\_  
 Vérifié & Approuvé par : \_\_\_\_\_  
 Commentaires : N° de pièce Dart Aerospace: D3140-06/-08 incite  
 N° de pièce Delastek Aeronautique: DKA359-0010/-0011  
 N° de pièce Delastek Composites: DKC135-0010/-0011  
 Process Sheet Rév.: 00

Produit additionnel

Numéro Job:



# Séq.: Machine ou Opération: Description :

1.0 LISTE MATÉRIEL LISTE DES MATÉRIAUX UTILISÉS


 Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs  
 LISTE DES MATÉRIAUX UTILISÉS

Voir séquences 2 à 15 pour la liste de matériel nécessaire à la fabrication de cette pièce.

2.0 AMB0211 PREPERG FIBERCOTE E761/7781 roul. 50"

Commentair Qty.: 24.50 VERGE(s)/Unit Total: 24.50 VERGE(s)

PREPERG FIBERCOTE E761/7781 roul. 50" 1-3362-1

A8756

~~A8756~~

3.0 AC0073 Tissu Blanc a Delaminer 1.5 M #3003251

Commentair Qty.: 12.0000 METRE CAR(s)/Unit Total: 12.0000 METRE CAR(s)

Tissu Blanc a Delaminer 1.5 M #3003251

4.0 AC0085 Film durisol # 3001792

Commentair Qty.: 18.0000 METRE CAR(s)/Unit Total: 18.0000 METRE CAR(s)

Film durisol # 3001792

5.0 AC0348 Feutre drainage AB1060 ép: 6mm #sap:3001752

Commentair Qty.: 18.0000 METRE CAR(s)/Unit Total: 18.0000 METRE CAR(s)

Feutre drainage AB1060 ép: 6mm #sap:3001752

6.0 AC0092 Sac à vide # sap 3001815

Commentair Qty.: 23.3000 METRE CAR(s)/Unit Total: 23.3000 METRE CAR(s)

Sac à vide # sap 3001815

7.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 6.0000 RL(s)/Unit Total: 6.0000 RL(s)

Ruban à gommer jaune #: T/AT-200Y

MATERIAUX Pour la Réparation.

 90Z lot # A2901  
 HYSOL 9309NA lot # 1-3146-1